



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3209-041
Job Sheet 182254



Part No: D3209-041

Job Qty: 10 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/21/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 04.06.09 New issue KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-2		18/09/18
100	Bandsaw	10 pcs	9/7/18	9/7/18	0.00	0.12	Bandsaw1		"
110	CNC Vertical Machining	10 pcs	9/7/18	9/7/18	0.35	5.92	HAAS1-3		"
120	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC2 Machining-2		"
130	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-2		18-09-17
140	HandFinish	10 pcs	9/7/18	9/7/18	0.00	0.35	HandFinish1		18/09/17
150	Powdercoat	10 pcs	9/7/18	9/7/18	0.00	0.28	Powdercoat3		18-09-19
160	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC3		
161	Small Fab	10 pcs	9/7/18	9/7/18	0.00	0.41	Small Fab-3		
170	QC	10 pcs	9/7/18	9/7/18	0.00	0.00	QC5		SEP 21 2018 68
180	Packaging	10 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		9-89
190	QC21-SA	10 Ea	9/7/18	9/7/18	0.00	0.00	QC21		SEP 22 2018

Part Op 100 - Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

Descriptions: 110 - Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1

150 - Note: Cover the hole for D3209-1 before powder coat.

161 - press fit bushing as per dwg

180 - LOCATION : GA

M 136370 START: 10:15 OUT: 320° FINISH: 10:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3209-3	Bushing	10 Ea (1 ea)	90-Start up Operation	F162823
M6061T6B1.500X1.250	6061-T6 Bar 1.50 X 1.25	1.7500 ft (.175 ea)	161-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3209-3	10	17	0
161-Small Fab	M6061T6B1.500X1.250	2	9	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

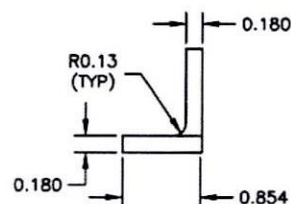
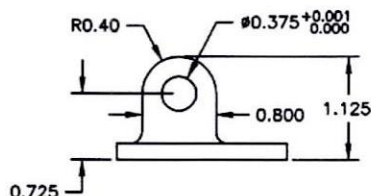
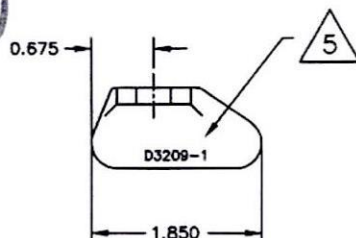
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART

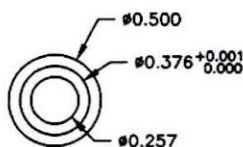
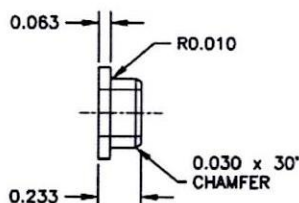
DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 [Signature]



2

D3209-1 BRACKET

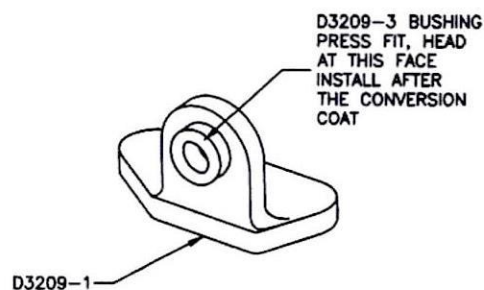


3

D3209-3 BUSHING
SCALE 1:2

4

D3209-041 ASSEMBLY



D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

-725
-725